

Work Order ID 75587

75587

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October-26-11 8:44:43 AM

Item ID: D2620 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube, 206 Skidtube
 Start Date: 26/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/26 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2620	Rev B

100 0.00
100 Skidtubes
 Skidtubes Memo 0.00
 Skidtubes 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
 206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

120 0.00
120 Identify as per dwg & Stock Location: 46
 Packaging Memo 0.00
 Packaging

MO 11-12-13
PTO

DP 11-12-13 (10)

DP 11-12-13 (10)

W/O:		75587 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2620 PAR #: _____ Fault Category: LANDING CR NCR: Yes No DQA: ✓ Date: 11/12/11
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: ✓ Date: 11/12/20

NCR:		WORK ORDER NON-CONFORMANCE (NCR) # 5.95						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-12-13	100	1 Tube collapsed (crushed) while bending. RC; Process	S 11/12/14 057042	Scrap + replace B# 73804 D2600-1-120	S 11-12-14	S 11/12/14 057042	S 11/12/14 057042	S 11/12/14

NOTE: Date & initial all entries

Work Order ID 75587***75587***

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October-26-11 8:44:43 AM

Item ID: D2620

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, 206 Skidtube

Start Date: 26/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

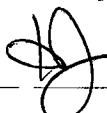
130

QC

Memo

0.00

Quality Control

11/12/14 MF
11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-26-11 8:44:47 AM

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Work Order ID: 75587

75587

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 26/10/2011

Required Date: 01/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	53.0000	1	10			

D2600-1-160

Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG 73804
43969
59875
68284

53
2
2
49

10

mo

11-12-13

120

DP

11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

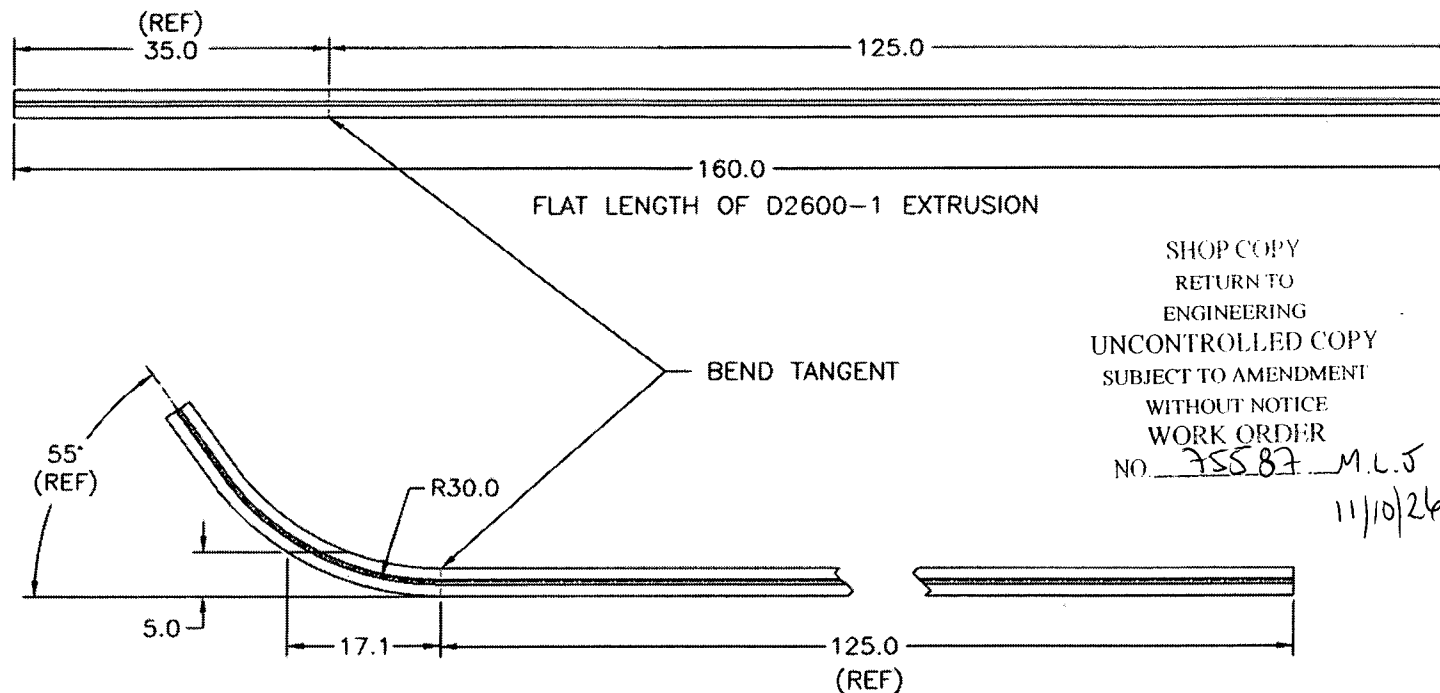
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75587 M.L.J.

11/10/26

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
99.04.15 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	NEW ISSUE	SCALE 1:20
B	UPDATE FOR IN-HOUSE BENDING	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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